

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP (CASTING DETAIL)
Job Number	: 29514		
Estimate Number	: 11088		
P.O. Number	: <i>NIA</i>	Part Number	: D25761
This Issue	: 11/17/2006      S.O. No. : <i>NIA</i>	Drawing Number	: D2576 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision	: E1
Previous Run	: <i>NIA</i>	Material	: <i>NIA</i>
Written By	: _____	Due Date	: 11/30/2006      Qty: 100      Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev: A      New Issue      05-11-29      JLM		

Job Number:

1.0	PG	PURCHASING
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Issue P/O: 2509  
Ship D2576 mould to vendor  
Cast per D2576-1 Pattern  
Material Release Note Required

c. Locality

100

2.0	D25761P	Step (Casting Detail)
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Receive & Inspect For Transit Damage  
Ensure D2576 mould is returned with the ordered parts  
Ensure release note is attached

LB 06/11/27 (100)

4.0 QC6 DIMENSIONAL CHECK

NA 06/11/30 (100)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Identify and Stock  
Location: 57/77-6A

✓ 4/12/00 (100)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DA Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:08:05 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 29514

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

06/12/04

Job Completion



06/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

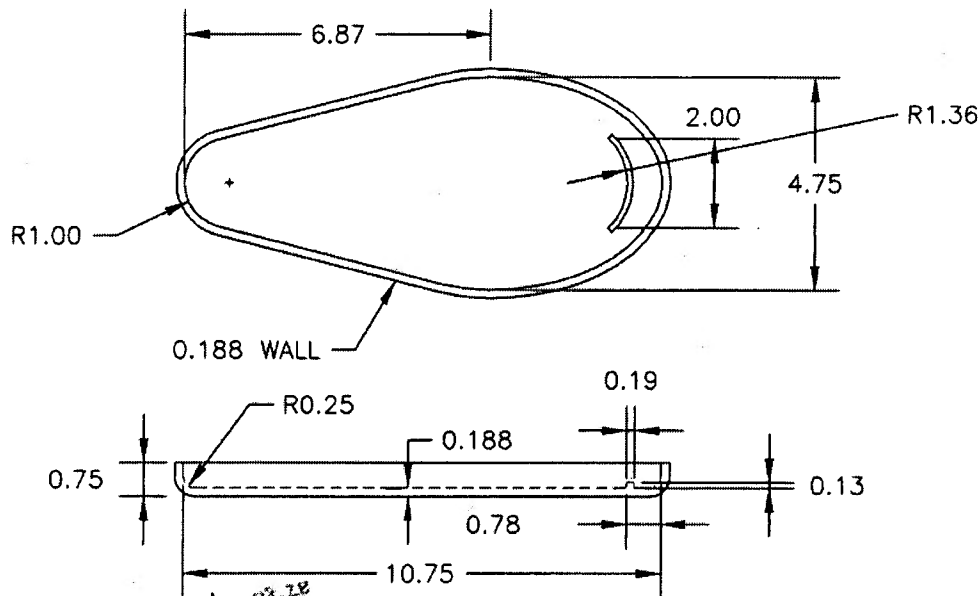
NOTE: Date & initial all entries



DESIGN <del>RF</del>	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>RF</del>	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	03.04.29	7.05 WAS 6.61	

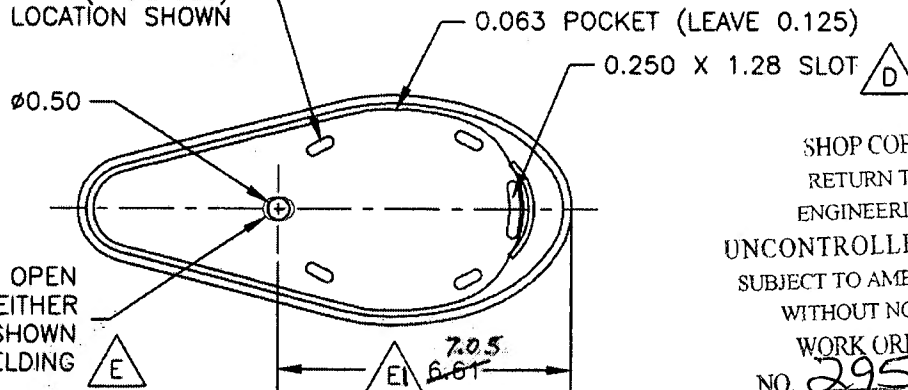
RELEASED  
99.09.08 DS

CASTING DETAIL (D2576-1) *#00.08.28*  
MATERIAL: CAST ALUMINUM ALLOY A-535.2  
BREAK SHARP EDGES 0.025 TO 0.050  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) *#00.08.28*

△ 0.250 X 0.65 SLOT  
(4 PLACES)  
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN  
THIS HOLE 0.125 IN EITHER  
DIRECTION AS SHOWN  
FOR WELDING △ E

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29514

**ALPINE NON-FERROUS FOUNDRY**8657-132ND STREET  
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

**Sold To: DART AEROSPACE**  
1270 ABERDEEN STREET  
HAWKESBURY, ONT  
CANADA K6A 1K7**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via		Page
17-Nov-2006		PO0002509	29-Nov-2006	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship
1	✓ DART D2576	D2576 STEP CSTG		100		100
2						

*DB*  
*06/11/27***Comments**

Castings &amp; Patterns are property of Alpine until paid in full

*Nov 24/06*

# CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS  
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746  
PH# (626) 369-3641 FAX# (626) 369-2471

## CUSTOMER:

RYPAC ALUMINUM  
11849 TANNERY ROAD  
SURREY BRITISH COLUMBIA,

## SHIP DATE

NOV 06 2006

CONFORMS TO ASTM SPECIFICATION: B179-03

Alloy: 535.2

Heat: G862

Si	0.044
Fe	0.074
Cu	0.001
Mn	0.131
Mg	6.770
Cr	0.001
Zn	0.003
Ti	0.167
Sn	0.003
Pb	0.001
Ni	0.001
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-.25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-.25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

*Ron Zakrzewski*

NOV 06 2006

RON ZAKRZEWSKI

DATE

LAB MANAGER

PM-12.01 Rev D 12/5/2001

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.